

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002740**Date Inspected:** 01-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG				

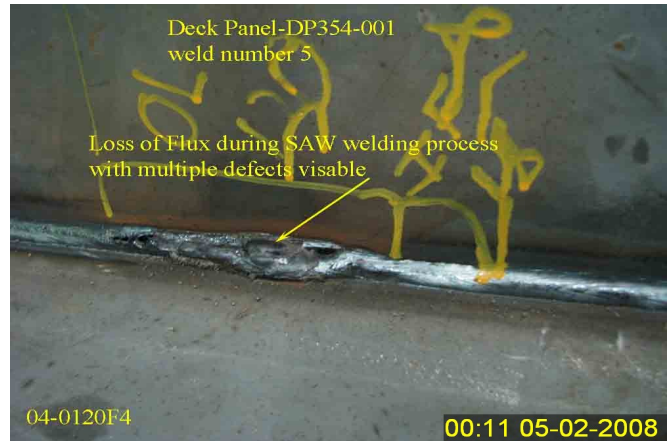
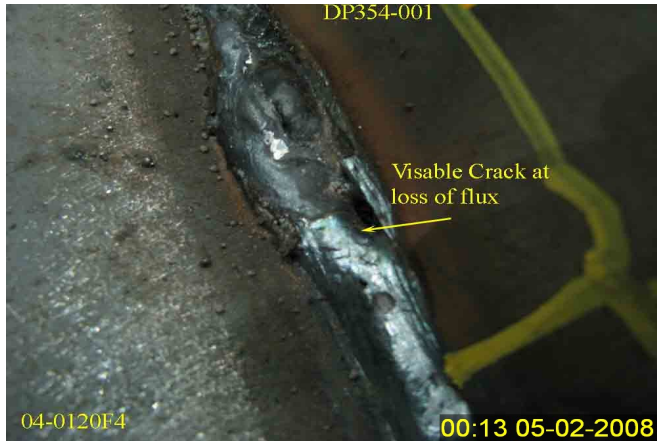
Summary of Items Observed:

Deck Panel VT

This Quality Control (QA) arrived at ZPMC for visual inspection of the Orthotropic Bridge Girders (OBG) Deck Plates that were welded by ZPMC. Visual Inspection performed for information only and was determined to have the following discontinuities at multiple locations; Insufficient Fusion (IF) Over Lap (OL), Under Fill (UF) and over sized welds within the weldments that were inspected. The deck plates inspected were numbers DP354-001 welds 1,2,3,7 and half of number 7. During the VT inspection it was also noted that on weld 5 ZPMC had a loss of flux during the Submerged Arc Welding (SAW) process which created several defects at this location. This QA inspector measured the area as follows; Y measurement of 19370 mm by 120 mm in length. DP113-002 partial VT inspection for welds 6, 7 and 8 along with DP408-001 welds 8 and 9. The locations and lengths of the discontinuities were recorded for tracking and distributed to the appropriate personnel for review.

WELDING INSPECTION REPORT

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Summary of Conversations:

No Conversations noted.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Pat Lowry (858) 344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
